

Work Order ID 127385

127385

Page 1

December-17-14 1:21:48 PM

Item ID: D412-698-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Automatic Door Opener
 Start Date: 12/11/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 12/19/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-12-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
3-23

MCS 150320 2

DAS
46
9-89
MAR 23 2015

DAS
27
3-23

MAR 19 2015

DAS
46
9-89
MAR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 Required Date: 12/19/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				(2x)	DAS 46		MAR 23 2015
130							9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>FG-022</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS 1503-23
 ME
 15-3-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:21:47 PM

Page 1

Work Order ID: 127385

127385

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener

Start Date: 12/11/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 07-07-12 JLM

IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-11 Door Prop		Manufactured	No			120	Each	22.0000	1	2			
D3552-11	DAS 46 9-89								**			DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				4					
				80345				2					
				96447				2	B12349	2			
				ST363				18					
				117123				18					
D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	20.0000	1	2			
D3594-043	DAS 46 9-89								**			DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST504				20					
				118979				19					
				119574				1					
D3594-044 Floor Doubler Assembly, RH		Manufactured	No			120	Each	13.0000	1	2			
D3594-044	DAS 46 9-89								**			DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST504				13					
				115188				1					
				119043				12					

MAR 19 2015

MAR 19 2015

MAR 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:21:48 PM

Work Order ID: 127385

127385

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener

Start Date: 12/11/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

D3594-5 Manufactured No

120 Each

21.0000

1 2

D3594-5

DAS

46

Doubler

9-89

27
MAR 19 2015

Location

Loc Qty

Loc Code

ST050

21

116732

11

123617

10

D3622-1 Manufactured No

120 Each

36.0000

2 4

D3622-1

DAS

46

Ball Stud

9-89

DAS
27
MAR 19 2015

Location

Loc Qty

Loc Code

ST052

36

123724

4

124028

32

MS20426AD4-4 Purchased No

120 Each

1,461.000

2 4

MS20426AD4-4

DAS

46

Rivet

9-89

DAS
27
MAR 19 2015

Location

Loc Qty

Loc Code

CCK004

1098

125445

1098

GA

363

125445

363

MS21073L5 Purchased No

120 Each

12.0000

1 2

MS21073L5

DAS

46

Anchor Nut

9-89

DAS
27
MAR 19 2015

Location

Loc Qty

Loc Code

ST300

12

m130799

12

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 127385

127385

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener

Start Date: 12/11/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

120

Each

411.0000

2

4

NAS1149D0516.J

DAS

**

DAS

27

DAS

CS

Washer

46

9-89

9-89

9-89

Location

Loc Qty

Loc Code

ST269

411

M129706

411

MAR 19 2015

DQA: _____ Date: _____



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MAR 23 2015

DAS
46
9-89

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW